

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-600 REV E AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-600 REV 5

REF. TCCA STC: SH93-88

REF. FAA STC: SR00098NY and SR00099NY

REF. EASA STC EASA.1M.R.S.01292

1.0 PURPOSE



It has come to Dart's attention that on later model AS350 aircraft, the angle type tie-down brackets used to attach the Cargo Restraint Netting in the side cargo compartment have been changed to 'D-Ring' brackets. The purpose of this DSI is to provide instructions and parts list to allow the 'D-Ring' brackets to be installed on the Dart Spacepod. DXXX-600-141/-142/-143 at CHG 005 and DXXX-600-241/-242/-243 at CHG 002 are factory modified with this update and parts lists are affected as per Section 3.0 of this service instruction. Note that it is also acceptable to install the DS19700-011 Insert Kit on Spacepods that have been installed on earlier model AS350/355 aircraft. Note: For DXXX-600-041/-042/-043 Spacepods with built in composite floors, it is acceptable to install the D-ring brackets directly to the composite floor.

2.0 PROCEDURE



- 2.1 Ensure the D3187-1/-2 Floor is installed on the Spacepod body per Step 3.2.1b of IIN-D350-600.
- 2.2 Locate and mark the installation positions for the 'D-Ring' brackets, Qty 5-7, on the D3187-1/-2 Spacepod Floor, minimum 1.0 inches from the edge of the D3187-1/-2 Floor.
- 2.3 Drill one $\varnothing 0.201"$ hole per 'D-Ring' bracket through the D3187-1/-2 Floor and the top skin of the Spacepod composite floor.
- 2.4 Remove the D3187-1/-2 Floor from the Spacepod by removing the 28 mounting screws. Retain the fasteners.
- 2.5 Using the $\varnothing 0.201"$ holes as pilot holes, drill $\varnothing 0.565"$ holes into the Spacepod composite floor (do not score the far side of the sandwich material). Route the material under the hole and clean out the foam core material to at least 0.25" all around the hole, as shown in Figure 2. (Suggestion: a hex head wrench chucked into a slow speed drill makes this step easy and uniform)
- 2.7 Fill each hole approximately 2/3rds full with Hysol EA934NA (or Hysol EA956 A&B or Hysol EA9309.3NA or Magnabond 6398 or other approved equivalent in accordance with the aircraft maintenance manual). Place an 80-005-2-10 insert into each hole flush to the top surface.
- 2.8 To install each insert, use Hysol EA934NA (or equiv) in accordance with the manufacturer's instructions. The Hysol can be injected with a sealant gun or a syringe through the potting hole of the insert. The cavity is filled when Hysol appears in the opposite vent hole. Allow a minimum cure time of 24 hours at room temperature.
- 2.9 After the curing time, remove excess Hysol by sanding flush to the top surface of the insert.
- 2.10 Touch up finish using DuPont Highbuild Primer Grey #1104S or #1144S.
- 2.11 Re-install the D3187-1/-2 Floor using the retained fasteners (28X).
- 2.12 Install the "D-Ring" brackets using the AN3-6A bolts provided. Torque fasteners to 15-25 in-lb (1.7-2.8 Nm).

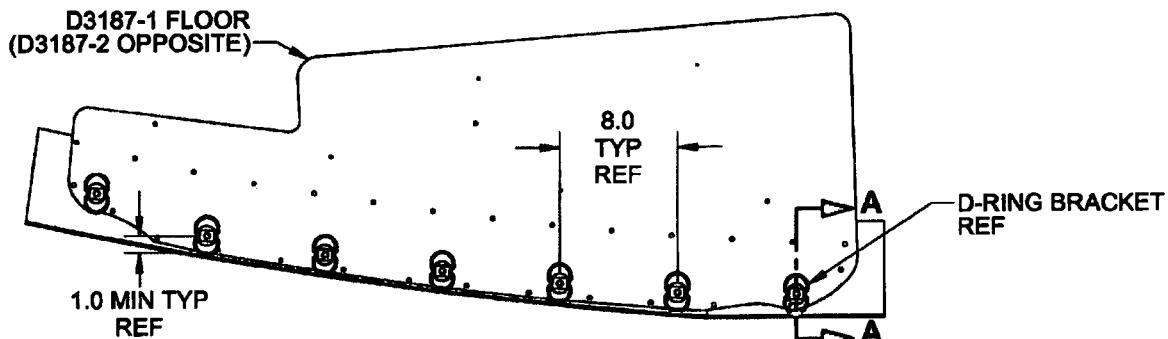
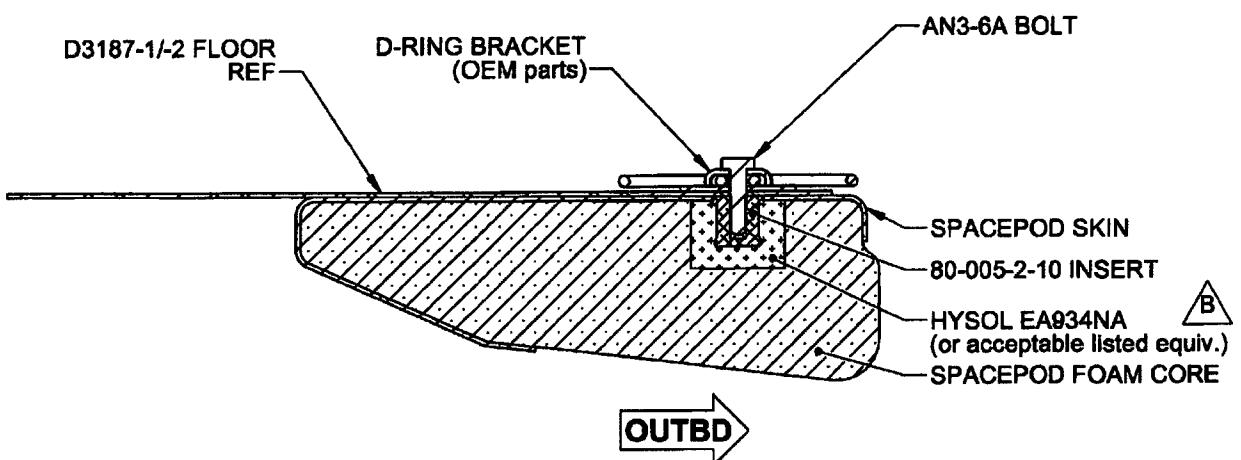


FIGURE 1: SPACEPOD FLOOR

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPPARD (DE # 02)
DATE:	14.09.29
CERT. NO.:	SH93-88
ISSUE NO.:	6

B	ADD NOTE FOR SPACEPODS W/BUILT IN FLOOR, ADD ALTERNATE ACCEPTABLE POTTING COMPOUNDS		DB	14.09.29
A	NEW ISSUE		DB	14.06.11
REV.	DESCRIPTION		BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DB			
CHECKED	B	DRAWING NO.		
MFG. APPR.	N/A	REV. B DSI 9700		
APPROVED	A	SHEET 1 OF 2		
DE APPR.	S	TITLE INSERT INSTALLATION		
DATE	14.09.29	SCALE NTS		
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**FIGURE 2: SECTION A-A
(VIEWED LOOKING FORWARD)**

3.0 PART LIST

QTY -011	P/N	DESCRIPTION
X	DSI-9700-011	INSERT INSTALLATION KIT
7	80-005-2-10	INSERT (#10-32 UNF)
7	AN3-6A	BOLT

-141	-142	-143	Part Number	Description	
X			D350-600-141	SPACEPOD™ LH, AS350	
	X		D350-600-142	SPACEPOD™ RH, AS350/AS355	
		X	D355-600-143	SPACEPOD™ LH, AS355	
7	7	7	AN3-6A	BOLT	(ADD)
7**	7**	7**	80-005-2-10	INSERT (#10-32 UNF)	(ADD)

-241	-242	-243	Part Number	Description	
X			D350-600-241	SPACEPOD™ LH, AS350	
	X		D350-600-242	SPACEPOD™ RH, AS350/AS355	
		X	D355-600-243	SPACEPOD™ LH, AS355	
7	7	7	AN3-6A	BOLT	(ADD)
7**	7**	7**	80-005-2-10	INSERT (#10-32 UNF)	(ADD)

**PRE-INSTALLED ON D3188-1/2-3/5/6/7 SPACEPOD BODY

4.0 WEIGHT AND BALANCE

There is no Weight and Balance change associated with this update.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
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CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9700	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	INSERT INSTALLATION	NTS
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